

Work Order ID 151393

Friday, September 23, 2016 2:49:24 PM

151393

Page 1

Item ID: D2369-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Locator Plate
Start Date: 9/21/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference: **DAS 21 9-89**

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 26 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2369	B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.14

FLOW CNC Waterjet

1-Cut as per Dwg D2369

Dwg Rev: BProg Rev: B
2-Deburr if necessary(6)02/16/10/08

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

(6)02/16/10/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 151393

Friday, September 23, 2016 2:49:24 PM

151393

Page 2

Item ID: D2369-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Locator Plate
Start Date: 9/21/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.02							
Quality Control									OCT 11 2016
150	Identify as per dwg & Stock Location: <u>5225A</u>	0.00							
150									
Packaging	Memo	0.01							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89
OCT 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																						
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																																																																																				
Description Work Order Deviation			Disposition																																																																																																																																					
			Completed By																																																																																																																																					
			Lead hand / Supervisor Approval Verification																																																																																																																																					
			QC / QA Coordinator Approval																																																																																																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:10%;">Environment</td><td style="width:10%;">☐</td><td style="width:10%;">No Re-verification</td> <td style="width:10%;">☐</td> <td style="width:10%;">Pressure/Forced</td> <td style="width:10%;">☐</td> <td style="width:10%;">Temperature/Cure</td> <td style="width:10%;">☐</td> <td style="width:10%;">Power Loss/Surge</td> <td style="width:10%;">☐</td> <td style="width:10%;">Positioned Wrong</td> </tr> <tr> <td>Design</td><td>☐</td><td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>Set-up</td> <td>☐</td> <td>Folio/Program</td> <td>☐</td> <td>Outside Dimensions</td> </tr> <tr> <td>Doc/Data</td><td>☐</td><td>Offset/Setup</td> <td>☐</td> <td>Centre Not Concentric</td> <td>☐</td> <td>BOM/Route</td> <td>☐</td> <td>Grain</td> <td>☐</td> <td>Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td><td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Broken/Damage/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> <td>Part Incorrect</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td><td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Inspection Incomplete/Unqualified</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Material</td><td>☐</td><td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Part Moved</td> </tr> <tr> <td>Internal Transport</td><td>☐</td><td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> <td>Drawing</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td><td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> <td>Finish</td> </tr> <tr> <td>LOA</td><td>☐</td><td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Misread</td> </tr> <tr> <td>Substation</td><td>☐</td><td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Turning Sequence</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td> <td colspan="8" rowspan="2" style="vertical-align: top;">OTHER :</td> </tr> <tr> <td>Misidentified</td><td>☐</td><td>Past Due</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY				Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	Past Expiry Date	☐	Manufacturing Process	OTHER :								Misidentified	☐	Past Due
Root Cause			FAULT CATEGORY																																																																																																																																					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong																																																																																																																														
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions																																																																																																																														
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance																																																																																																																														
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect																																																																																																																														
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing																																																																																																																														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved																																																																																																																														
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing																																																																																																																														
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish																																																																																																																														
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread																																																																																																																														
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence																																																																																																																														
Past Expiry Date	☐	Manufacturing Process	OTHER :																																																																																																																																					
Misidentified	☐	Past Due																																																																																																																																						

Picklist Print

Friday, September 23, 2016 2:49:23 PM

Page 1

Work Order ID: 151393

151393

Parent Item: D2369-3

D2369-3

Parent Item Name: Locator Plate

Start Date: 9/21/2016

Required Date: 9/23/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
 IPP Rev:B Now on Waterjet 07-05-28 JLM IPP REV:C
 13.05.21 AS PER DWG REV.B VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		110	sf	55.0137	1.354	8.551579			

M5052H32S 040

5052-H32 .040 Sheet

02/16/10/28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	18.7	
m135512	18.7	
MAT022	23.9	
m134774	23.9	
MAT023	12.413684	
m1342217	5.813684	
m134617	6.6	

2.8 4.5
4.5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

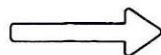
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

5.000
4.500

Ø0.128
6PL

D2369-1



F W D

D2369-1 DECK PLATE LOCATOR BRACKET

0.500
0

0.940

5.649

B

R0.25 TYP

34.297
37.996
38.297
4.451
0.549
35.000
38.544
39.000

LABEL (D2364 UP)

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

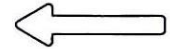
WITHOUT NOTICE
WORK ORDER

NO. 151393 MCT
1609-26

5.000
4.500

Ø0.128
6PL

F W D



D2369-3

D2369-3 DECK PLATE LOCATOR BRACKET

0.500
0

0.940

5.649

B

R0.25 TYP

37.641
37.990
38.297
4.490
0.664
38.344
38.528
39.000

LABEL (D2344 UP)

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: 6061-T6 SHEET, 0.040" THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209 (REF: DART SPEC M5052H32S.040) OR 5052-H32 ALUMINUM SHEET, 0.040" THICK AS PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209 (REF: DART SPEC M5052H32S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) PROFILE PER DRAWING FILE "D2369-1-REVB.DXF" OR "D2369-3-REVB.DXF"

B	DRAWING RE-FORMATED TO NEW STANDARD, 5052-H32 WAS 5052-H34, ADD 6061-T6 MATERIAL OPTION (ZN A8-1) 0.940 WAS 1.000, 5.649 WAS 5.709 (ZN B6-1, ZN B7-1, ZN C6-1, ZN C7-1), REF CIR13-15	DB	13.03.22
A	NEW RELEASE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	2/		
APPROVED	NO		
DE APPR.	W		
DATE	13.03.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2369 REV. B SHEET 1 OF 1 TITLE DECK PLATE LOCATOR BRACKET NTS SCALE COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			